

Work Order ID 59916

June 17, 2010 8:16:48 AM



Page 1

Item ID: D3137-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket Assembly

Start Date: 18/06/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 30/06/2010 Req'd Qty: 6.00

Customer:

Reference:

10/06/18

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3137

Rev F

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: (.500" x 2.000") 5.570" long

10/06/17

6

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine D3137-7 as per Folio FA3308 and Dwg D3137 Identify as D3137-7□2-
Deburr□3-Scribe batch number

10/06/20

6

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

10/06/20

6

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Page 2

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Setup Start



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Item Name: Bracket Assembly

Start Date: 18/06/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 30/06/2010 Req'd Qty: 6.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

aml 10/06/21



QC

Memo

0.00

6 0

Quality Control

140

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Assemble D3137-043 as per Dwg D3137

JS 10/06/21 (6)

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

S 10/06/21

(+6)

Quality Control

Work Order ID 59916

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Page 3

Item ID: D3137-043

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Setup Start



Revision ID:

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Item Name: Bracket Assembly

Start Date: 18/06/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 30/06/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: 2353

0.00



Packaging

Memo

0.00

Packaging

18/06/2010 (6)

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/2010 (6)

mf
10-6-21

Picklist Print

June 17, 2010 8:16:47 AM

Page 1

Work Order ID: 59916

Parent Item: D3137-043

Parent Item Name: Bracket Assembly




Start Date: 18/06/2010

Required Date: 30/06/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 04.02.18 New issue KJ/DS
IPP Rev B 08.07.03 ECN1207 EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3137-3  Guide		Manufactured	No			140	Each	14.0000	1	6			
<div> <div>Location</div> <div>ST235B</div> <div>54449</div> <div>59634</div> </div> <div> <div>Loc Qty</div> <div>14</div> <div>4</div> <div>10</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													
D3137-5  Washer		Manufactured	No			140	Each	19.0000	1	6			
<div> <div>Location</div> <div>ST235B</div> <div>46740</div> </div> <div> <div>Loc Qty</div> <div>19</div> <div>19</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
M174B0.500X02.000  17-4 SS Bar .500 x 2.00		Purchased	No			140	f	68.0000	0.4643	2.932421			
<div> <div>Location</div> <div>MAT030</div> <div>100843</div> <div>103089</div> <div>14932</div> <div>19572</div> </div> <div> <div>Loc Qty</div> <div>68</div> <div>13</div> <div>18.5</div> <div>26</div> <div>10.5</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> <div></div> <div></div> </div>													

EP 10/06/21

EP 10/06/21

2,8(f) 10/06/17

Picklist Print

Page 2

June 17, 2010 8:16:47 AM

Work Order ID: 59916



Parent Item: D3137-043



Parent Item Name: Bracket Assembly

Start Date: 18/06/2010

Required Date: 30/06/2010

Start Qty: 6.00

Required Qty: 6.00

MS24694-S101

Purchased

No

100

Each

80.0000

1



Screw



6
E/S 10/06/21

Location

Loc Qty

Loc Code

ST290A

80

110363

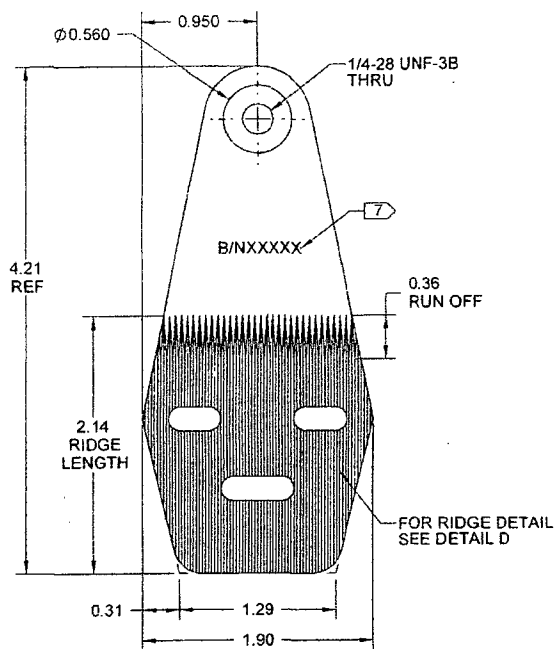
80

6

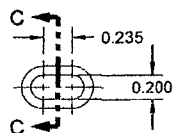
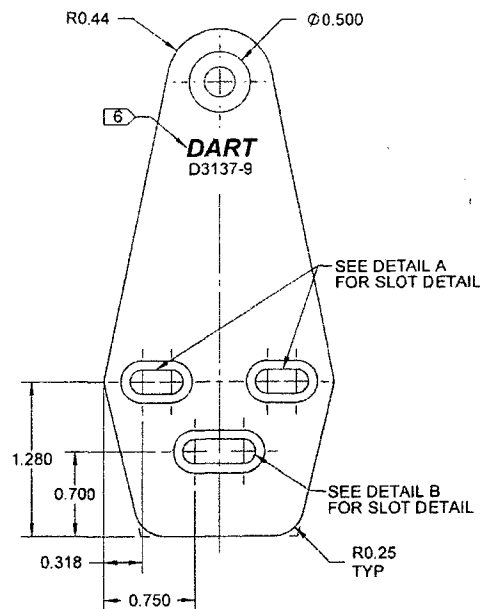
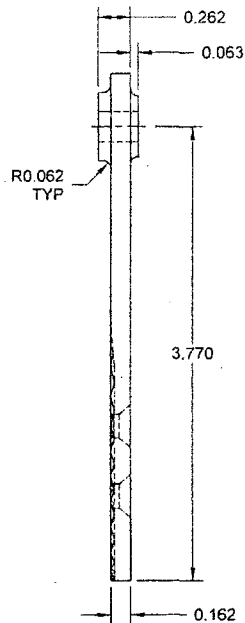
June 17, 2010 8:16:47 AM

Shop Packet Print

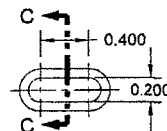
Page 2



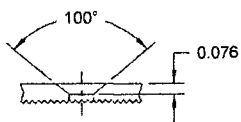
D3137-9 BRACKET



DETAIL A
(SLOT DETAIL)



DETAIL B
(SLOT DETAIL)



SECTION C-C
(SLOT DETAIL)



DETAIL D
SCALE 2X
(TYPICAL RIDGE DETAIL)

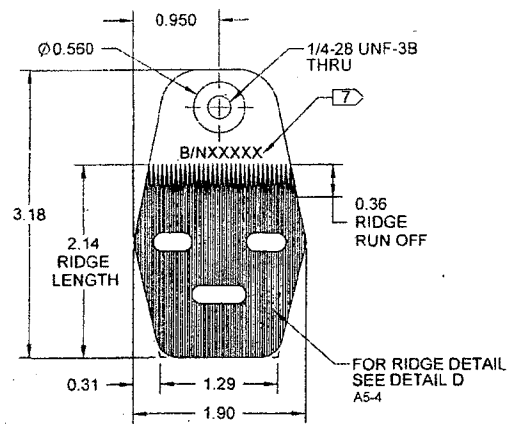
NOTES:

- 1) MATERIAL: 17-4PH STAINLESS STEEL
PER AMS 5604 OR 5643
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
PER DART SPEC. M17-4-B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: ENGRAVE DART LOGO USING 0.20 HIGH LETTERS & P/N WITH USING .15 HIGH LETTERS TO A MAX. DEPTH OF 0.010.
- 7) SCRIBE WITH DART B/N USING VIBRATING STYLUS
- 8) WEIGHT: SEE ASSEMBLED WEIGHT ON SHEET 2
- 9) REPLACES PREMIER P/N B30-23000-105/-106

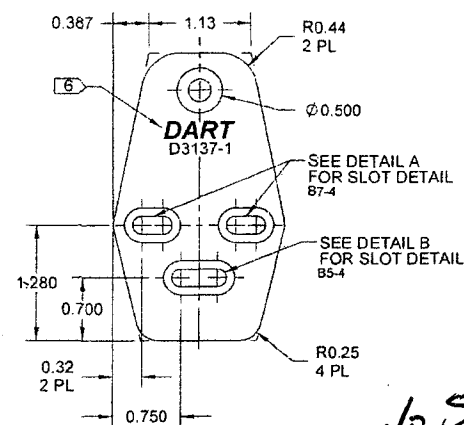
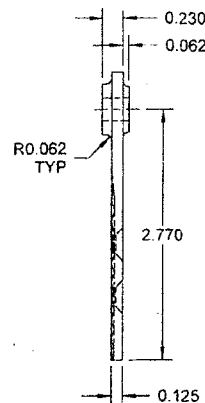
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DRAWN	A/S	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3137	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BRACKET ASSEMBLY	NTS
DATE	08.05.30	<small>COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR LOANED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

w/o 59916.

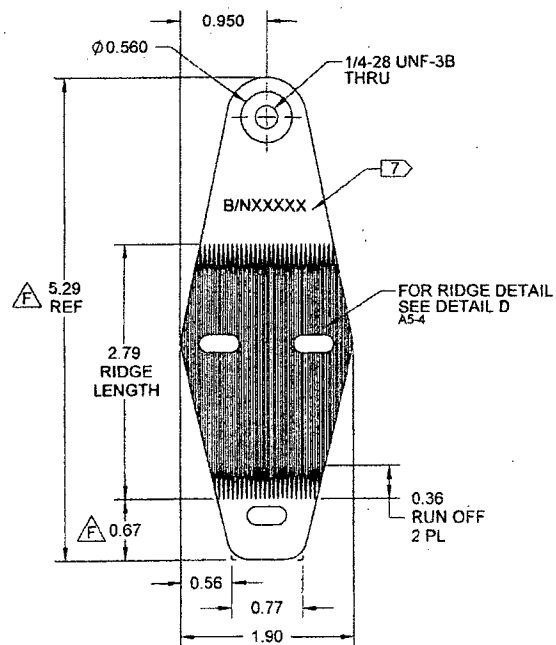
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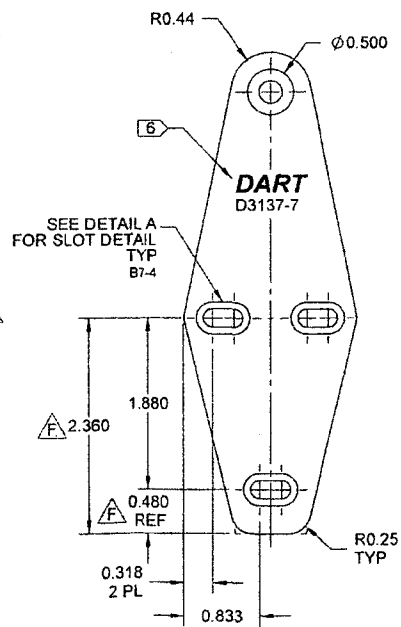
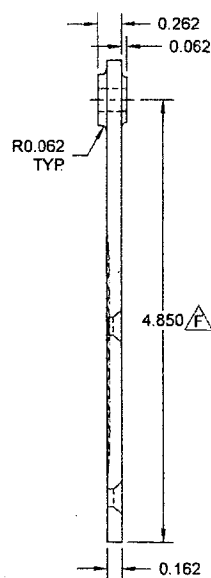
D3137-1 BRACKET



w/p 59916



D3137-7 BRACKET

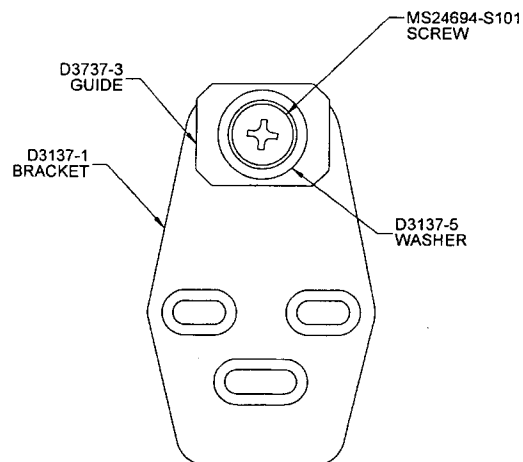


- NOTES:**
- 1) MATERIAL: -1 & -7
17-4PH STAINLESS STEEL
PER AMS 5604 OR 5643
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
PER DART SPEC. M17-4-B
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
 - 6) IDENTIFICATION: ENGRAVE DART LOGO USING 0.20 HIGH LETTERS & P/N WITH USING .15 HIGH LETTERS TO A MAX. DEPTH OF 0.010.
 - 7) SCRIBE WITH DART B/N USING VIBRATING STYLUS
 - 8) WEIGHT: SEE ASSEMBLED WEIGHT ON SHEET 2
 - 9) -1 REPLACES PREMIER P/N B30-23000-105/-1

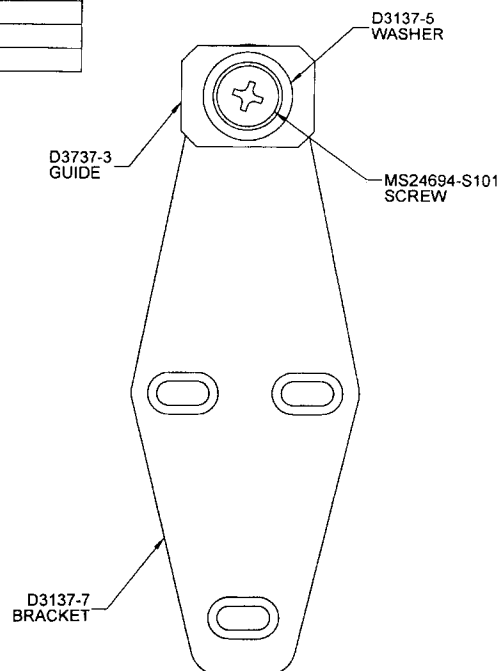
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08.06.26.1410

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CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3137	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BRACKET ASSEMBLY	NTS
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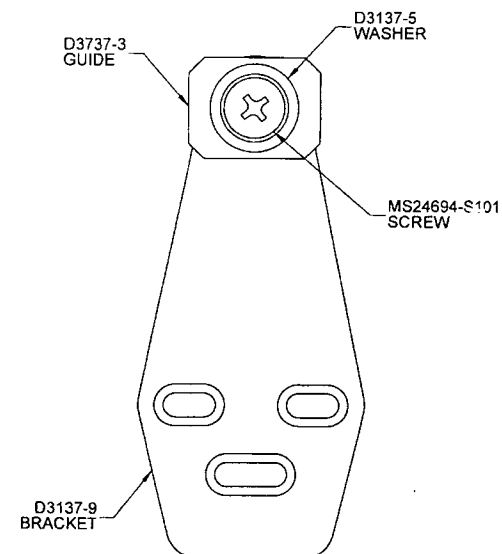
QTY. -041	QTY. -043	QTY. -045	PART NUMBER	DESCRIPTION
X			D3137-041	BRACKET ASSEMBLY
	X		D3137-043	BRACKET ASSEMBLY
		X	D3137-045	BRACKET ASSEMBLY
1			D3137-1	BRACKET
1	1	1	D3137-3	GUIDE
1	1	1	D3137-5	WASHER
	1		D3137-7	BRACKET
		1	D3137-9	BRACKET
1	1	1	MS24694-S101	SCREW



D3137-041 BRACKET ASSEMBLY



D3137-043 BRACKET ASSEMBLY



D3137-045 BRACKET ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.18 lbs -041
0.32 lbs -043
0.27 lbs -045

RELEASED
08.06.26/10

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	AS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3137	SHEET 2 OF 5
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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

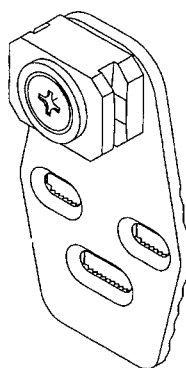
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

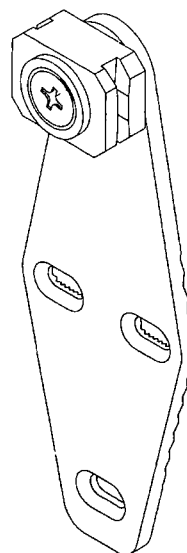
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

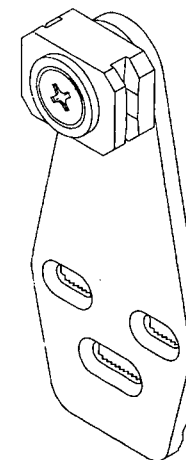
#59916



D3137-041 BRACKET ASSEMBLY



D3137-043 BRACKET ASSEMBLY



D3137-045 BRACKET ASSEMBLY

RELEASE
08-06-2017

F	REDRAWN & REFORMATTED IN SOLIDWORKS. SHEET 3 ZONE A.5 DIM 2.36 WAS 2.48. ZONE A.4 0.480 DIM WAS 0.605. ZONE A.8 0.67 DIM WAS 0.79. ZONE B.5 4.850 DIM WAS 4.975 & ZONE B.8 5.29 DIM WAS 5.41. REASON: PART TRIMMED DUE TO INTERFERENCE WITH EXECUTIVE INTERIOR.	AJS	08.05.30
E	ADD -045	RF	05.11.23
D	RE-DESIGN D3137-5; CHANGE DIMS	DS	04.11.03
C	ADD -043	DS	03.08.15
B	ADD RIDGES; ADD MATERIAL PROP	DS	03.01.16
A	NEW ISSUE	DS	02.04.17
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3137	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BRACKET ASSEMBLY	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries